

20-7991



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.0310

Job Sheet 204985



Part No: 647.0310

Job Qty: 16 pcs

Part Name: Channel



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/23/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 2/14/20

Description:

Type: Stock *SOLD*

Note: DWG REV N/C IPP REV: A NEW ISSUE 12/09/18 JFS VERIFY BY DD

Ship Via:

Bill of Materials

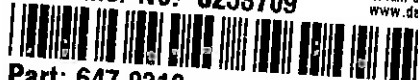
Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter / Supplier Lead Time	Sign-off
					Setup Hrs	Run Hrs		
100	Bandsaw - 1	16 pcs	2/14/20	2/14/20	0.00	2.01	Bandsaw - 1	
110	HAAS 4 Axis - B4B	16 pcs	2/14/20	2/14/20	0.25	7.41	HAAS - 1 - B4B	
							HAAS - 2 - B4B	
							HAAS - 3 - B4B	
							HAAS - 4 - B4B	
130	QC 8	16 pcs	2/14/20	2/14/20	0.00	0.00	QC 8 - 12	
							QC 8 - 14	
							QC 8 - 17	
							QC 8 - 20	
							QC 8 - 25	
							QC 8 - 3	
							QC 8 - 32	
							QC 8 - 33	
							QC 8 - 35	
							QC 8 - 39	
							QC 8 - 4	
							QC 8 - 44	
							QC 8 - 45	
							QC 8 - 49	
							QC 8 - 58	
							QC 8 - 8	
							QC 8 - 9	
							QC 8 - 68	
							QC 8 - 67	
							QC 8 - 1 (A)	
							QC 8 - 47	
							QC 8 - 40	
							QC 8 - 52	
							QC 8 - 23	
							QC 8 - 57	
							QC 8 - 76	



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CANADA
TEL: 1 813 632-5200
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www.dartaerospace.com

Container No: S253709



Part: 647.0310

Job No: 204985

Serial No/Batch: S253709

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/08/20

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				QC 8 - 61			
140	Outsource - 4 - Anodize	16 pcs	2/14/20		ATG001-VC	10	
150	Packaging 2-1 - Receive - B4B	16 pcs	2/14/20	0.00 0.00	Packaging 2 - 1 - B4B		2020-02-14 MAR 03 2020
					Packaging 2 - 2 - B4B		
					Packaging 2 - 3 - B4B		
					Packaging 2 - 5 - B4B		
					Packaging 2 - 4 - B4B		
					Packaging 2 - 6 - B4B		
					Packaging 2 - 7 - B4B		
					Packaging 2 - 8 - B4B		
					Packaging 2 - 9 - B4B		
					Packaging 2 - 10 - B4B		
					Packaging 2 - 11 - B4B		
					Packaging 2 - 12 - B4B		
					Packaging 2 - 13 - B4B		
					Packaging 2 - 14 - B4B		
					Packaging 2 - 15 - B4B		
					Packaging 2 - 16 - B4B		
					Packaging 2 - 17 - B4B		
					Packaging 2 - 18 - B4B		
					Packaging 2 - 19 - B4B		
					Packaging 2 - 20 - B4B		
					Packaging 2 - 21 - B4B		
					Packaging 2 - 22 - B4B		
					Packaging 2 - 23 - B4B		
					Packaging 2 - 24 - B4B		
					Packaging 2 - 25 - B4B		
					Packaging 2 - 26 - B4B		
					Packaging 2 - 27 - B4B		
					Packaging 2 - 28 - B4B		
					Packaging 2 - 29 - B4B		
					Packaging 2 - 30 - B4B		
					Packaging 2 - 31 - B4B		
					Packaging 2 - 32 - B4B		
					Packaging 2 - 33 - B4B		
					Packaging 2 - 34 - B4B		
					Packaging 2 - 35 - B4B		
					Packaging 2 - 36 - B4B		
					Packaging 2 - 37 - B4B		
155	QC 6	16 pcs	2/14/20	0.00 0.00	QC 6 - 9		DAS 40 9-89 DAS 82 9-89 MAR 03 2020
					QC 6 - 68		
					QC 6 - 61		
					QC 6 - 40		
					QC 6 - 81		
180	Packaging 3-1 - Stock - B4B	16 pcs	2/14/20	0.00 0.00	Packaging 3 - 1 - B4B		DAS 28 9-89
					Packaging 3 - 2 - B4B		
					Packaging 3 - 3 - B4B		
					Packaging 3 - 4 - B4B		
					Packaging 3 - 5 - B4B		
					Packaging 3 - 6 - B4B		
					Packaging 3 - 7 - B4B		
					Packaging 3 - 8 - B4B		
					Packaging 3 - 9 - B4B		
					Packaging 3 - 10 - B4B		
					Packaging 3 - 11 - B4B		
					Packaging 3 - 12 - B4B		
					Packaging 3 - 13 - B4B		
					Packaging 3 - 14 - B4B		
					Packaging 3 - 15 - B4B		

				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
190 QC 21 - SA	16 pcs	2/14/20	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	DAS
				QC 21 - SA - 53	21
Part Op 100 - (Bandsaw) Cut Blank at 8.025" Descriptions: 110 - (HAAS CNC Vertical Machine) 1-Machine per folio FB134 130 - (QC8- Inspect parts - second check) 140 - Issue P/O to ATG : <u>158067</u> Hard Anodize Black / Prime as per Dwg 647.0300 150 - (Receive & Inspect for Damage & Mat'l Certs) 155 - (QC6- All purchased or subcontracted products) 180 - (Identify as per dwg & Stock Location: _____) ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV*** 190 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M7075T6S1.250X2.000	7075-T6 Sheet 1.250" X 2.000"	10.7040 ft (.669 ea)	100-Bandsaw - 1	5030137	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Bandsaw - 1	M7075T6S1.250X2.000	11	87	0	

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Channel	1.750Inches $\pm$ 0.010	1.760 1.740	1.750	
2	Channel	0.100Inches $\pm$ 0.010	0.110 0.090	0.101	
3	Channel	0.770Inches $\pm$ 0.010	0.780 0.760	0.769	
4	Channel	0.860Inches $\pm$ 0.010	0.870 0.850	0.858	
5	Channel	0.190Inches $\pm$ 0.010	0.200 0.180	0.190	
6	Channel	0.880Inches $\pm$ 0.010	0.890 0.870	0.088	Radius
7	Channel	0.290Inches $\pm$ 0.010	0.300 0.280	0.280	0.088 Not .880
8	Channel	45.000Degrees $\pm$ 0.500	45.500 44.500	45	Angle
9	Channel	0.780Inches $\pm$ 0.010	0.790 0.770	0.773	
10	Channel	7.150Inches $\pm$ 0.010	7.160 7.140	7.159	
11	Channel	7.900Inches $\pm$ 0.010	7.910 7.890	7.898	

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PURCHASE ORDER

POHB045869



Supplier: ATG001-VC
A.T.G. Industries Inc
760 INDUSTRIELLE STREET
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045869
PO Date: 2/14/20
Due Date: 2/28/20
Purchase Order
Revision:
Revision Date:
Issued By: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground
Pymt Terms: Net 60

Freight Terms:
Special Comments:

E-MAILED
2020-03-04

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	204935	647.0310	647.0300 Rev N/C	Channel : Various STC's Issue P/O to ATG : Hard Anodize Black / Prime as per Dwg 647.0300	Firmed XK	-	2/28/20	26 pcs	0 pcs	26 pcs	\$13.81/pcs	\$359.06
2	204118	C3-2-1	C3-2-1 Rev 11	Side Plate C-3 Hook Outsource process- Anodize per QSI017 4.1.10.1 -Issue P/O -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed X20	-	2/28/20	20 pcs	0 pcs	20 pcs	\$9.66/pcs	\$193.20
Grand Total:												\$552.26

Guerin



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PURCHASE ORDER

POHB045869



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 3/2/20 11:42 AM Dart.Guerin.Kimberley



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Pack List

Number: 919722

Date: 02-Mar-20

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
26 ea	Part: 647.0310 Rev: N/C Channel Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot#: 5236137 Expiry Date: 05/29/21 Job: 26965 Line: 1 PO: POHB045869		
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>MAR 02 2020</u> Certified Signature: _____ Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt. RECEIVED MAR 02 2020 DART AEROSPACE LTD. Made in Canada.			



Mar 5/2020



NCR No. 20-799

Route update only

Job: <u>204985</u> Part No. <u>647-0310</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☒ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐					
Date: <u>20/02/06</u>		Sequence #: <u>110</u>		QTY Affected: <u>8 3rd</u>		MRB (QSI042) DAS 9 9-89 <u>20-02-11</u>			
Description Work Order Deviation Parts are too short + step too short				Disposition Scrap + replace qty of 2 was scrap by accident. Only qty of 3 are scrap.				Completed By <u>JRD</u> 20-02-06 Lead hand / Supervisor <u>ank</u> <u>20/02/06</u> QC / QA Coordinator DAS 9 9-89 <u>20-02-11</u>	
Root Cause Operator ☒ Manufacturing Process ☐ Equip/Tooling ☒ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☒ Outside Tolerance ☒ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐				Other/Details:	